

Work Order ID 57644

April 12, 2010 3:19:57 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 12/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 20/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: PL Date: 10-4-12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221								
	2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221								
	3- tack weld mesh on basket as per dwg D2221								
	A/R ER316 S.S. Rod Batch: <u>m11679</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

PL 10.04.28

PD 10.04.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	810104129						
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M114207 Memo 1- Plug holes prior to 1ST COAT: 8:30AM START TIME: 8:30AM OVEN TEMPERATURE: 400°F FINISH TIME: 9:00AM ***** 2nd coat if necessary***** 2ND COAT: START TIME: 9:20AM OVEN TEMPERATURE: 400°F FINISH TIME: 9:50AM	0.00 0.00	10105102			1			

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

① BK 10-5-3.

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

w/ 57643

Memo

0.00

Packaging

① AR 10-5-3.

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04
BS 10-5-04
①

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Picklist Print

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Page 1

Work Order ID: 57644

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 12/04/2010

Required Date: 20/04/2010

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D2221-1 Manufactured No 100 Each 7.0000 1.0000
 Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

7

57182

7

✓ D2221-5 Manufactured No 100 Each 4.0000 2.0000
 Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

4

56203

4

✓ D2221-7 Manufactured No 100 Each 2.0000 1.0000
 Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

2

56202

2

Pl 10.04.22

Pl 10.04.22

Pl 10.04.22

W/O:		WORK ORDER CHANGES					
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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3 Manufactured No 100 Each 3.0000 2.0000
 Basket Hinge

Cpl 10.04.22

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	3	B57502 → 2
	54863	3	

✓ D2235-1 Manufactured No 100 Each 9.0000 2.0000
 Basket Rib

Pl 10.04.22

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	9	B57593 → 2
	56472	1	
	57433	8	

✓ D2581 Manufactured No 100 Each 51.0000 2.0000
 Mounting Bracket

Pl 10.04.22

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	51	
	46086	2	
	51745	2	
	55918	2	
	57185	45	2

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 12/04/2010

Required Date: 20/04/2010

Start Qty: 1.00

Required Qty: 1.00


✓ D3442-1 Manufactured No 100 Each 20.0000 2.0000

 Shim


Pl 1004-22

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 WA 20
 54071 1
 56579 19

B57401 → 2 Pl 1004-22

✓ D3825-041 Manufactured No 100 Each 0.0000 2.0000

 Rib Assembly (Basket End)

✓ D3826-041 Manufactured No 100 Each 2.0000 2.0000

 Rib / Gusset Assembly

Pl 1004-22

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 WA 2
 57281 2

B57432 → 2

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3827-041

Manufactured No

100

Each

2.0000

1.0000



Rib Assembly (Inboard)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

55982

2

2

0.0000

1.0000

D3832-1

Manufactured No

100

Each



Mesh (Base)

D3833-1

Manufactured No

100

Each

3.0000

2.0000



Mesh (Base End Face)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

56396

3

3

B57594 → 2

B57219 → ①

B57280 → ①

B57280 → ①

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Shop Packet Print

Page 4

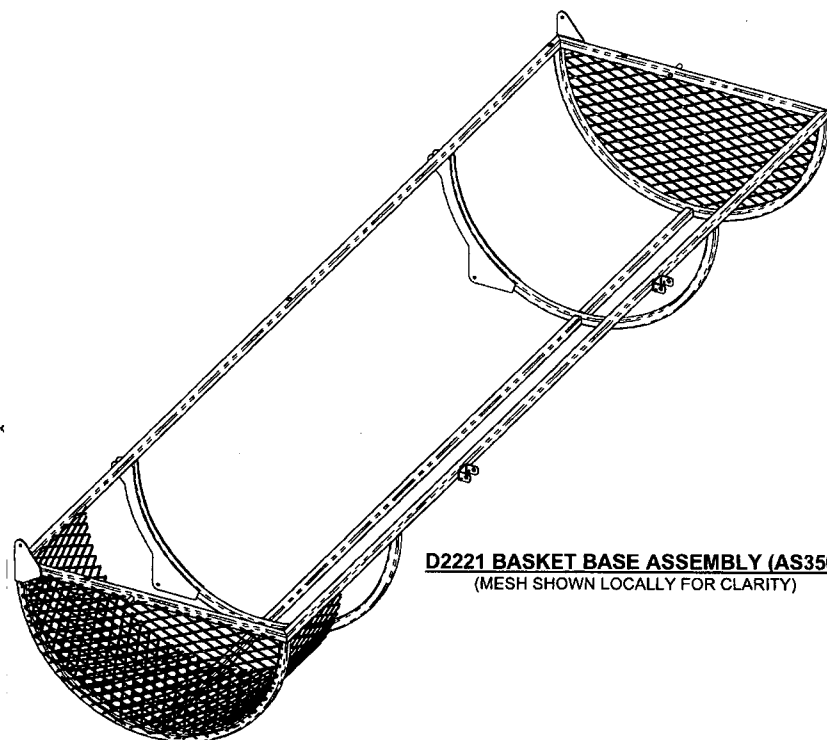
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 57644

B810-4-12

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	85.11.21
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

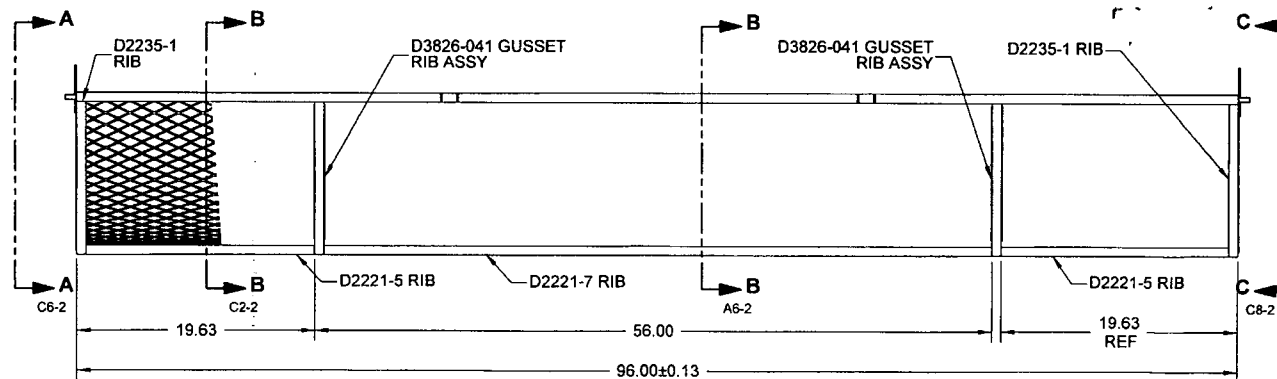
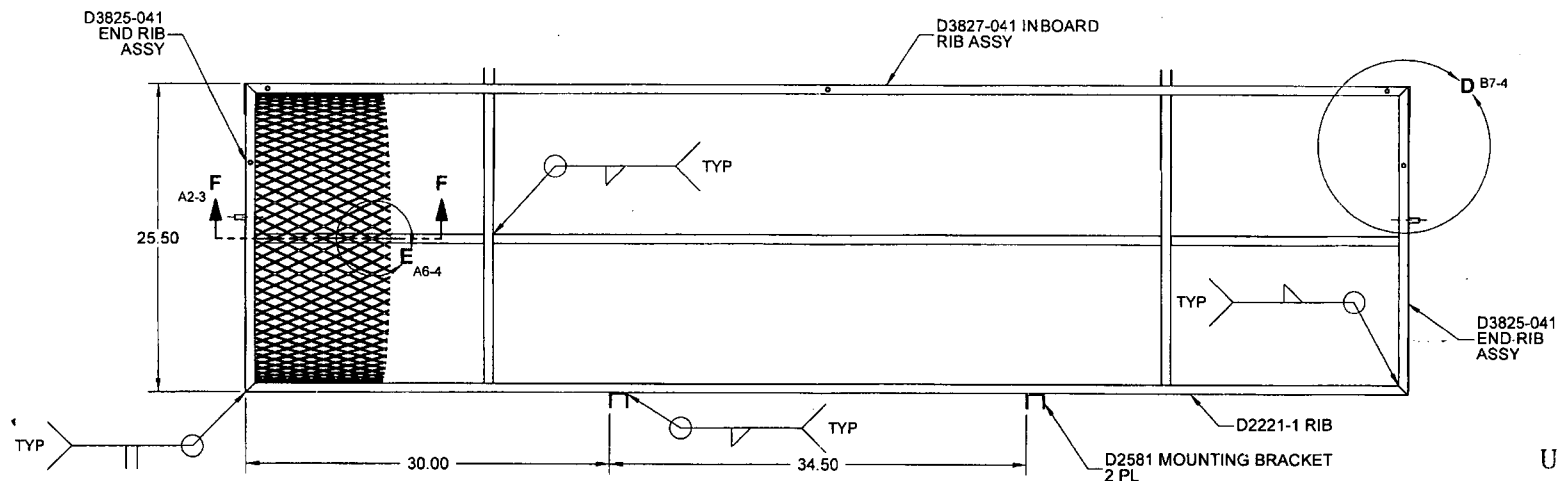
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57644
BS10-4-12

RELEASED
06/11/18

DESIGN	B/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

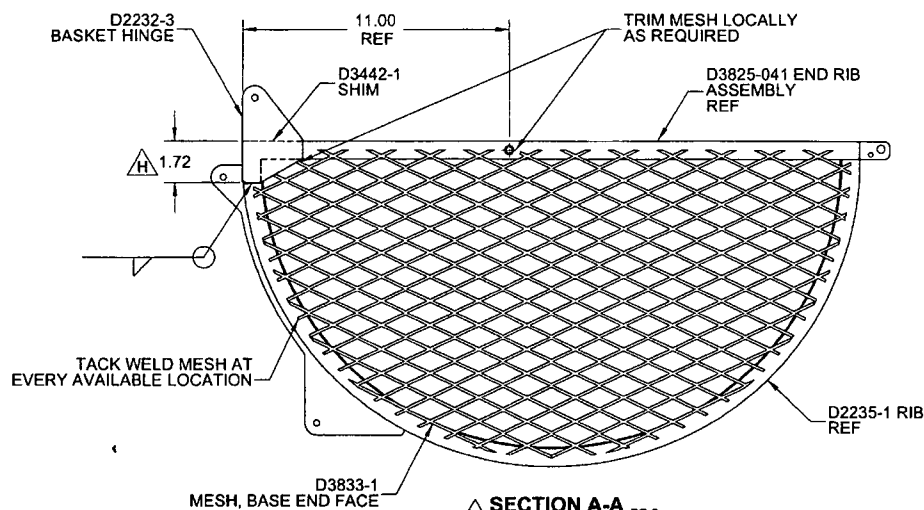
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

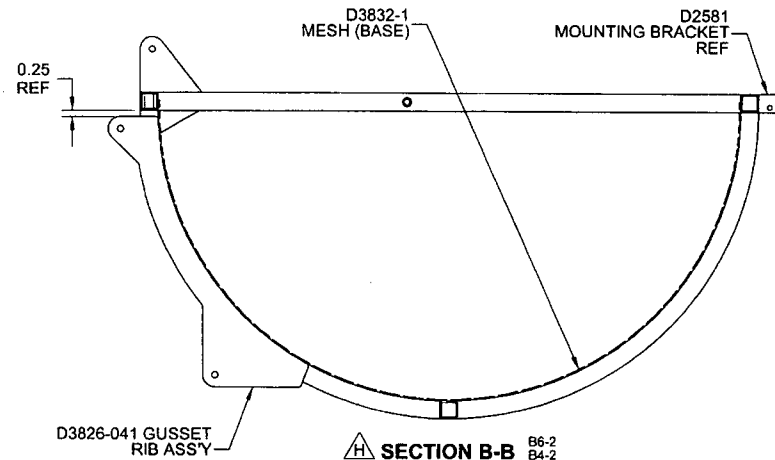
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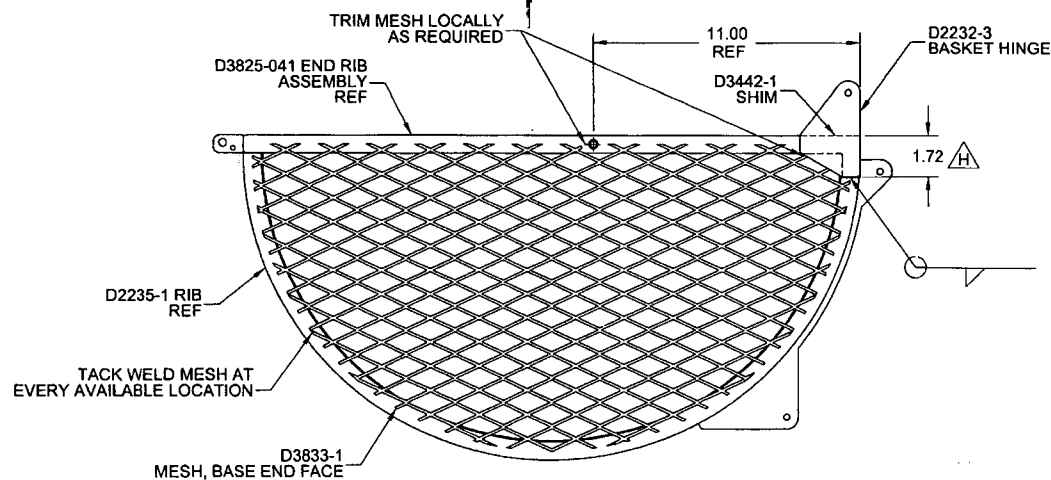
NOTE: Date & initial all entries



SECTION A-A B7-2
SCALE 2X



SECTION B-B B6-2
B4-2
SCALE 2X
(D3833-1 MESH NOT SHOWN FOR CLARITY)



SECTION C-C B2-2
SCALE 2X

W/D 57644

RELEASE
08/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
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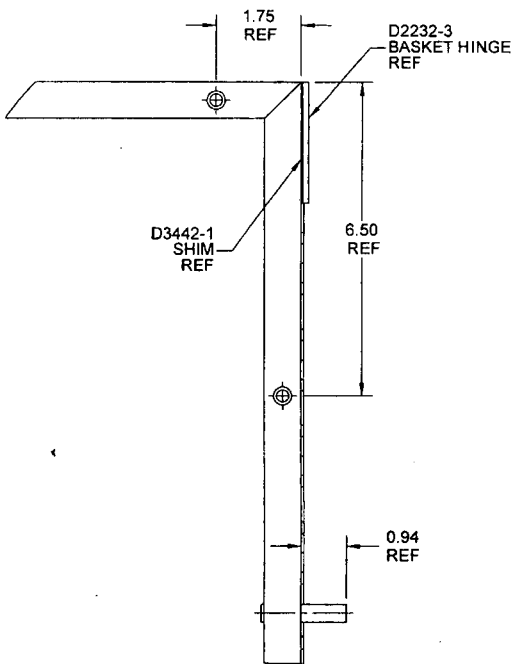
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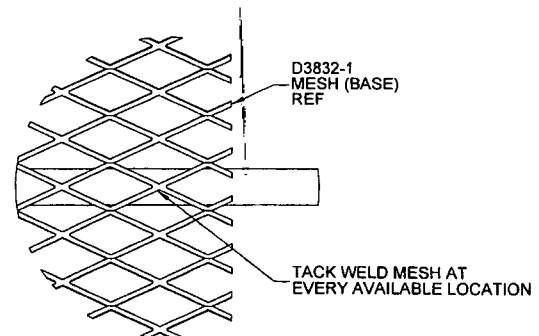
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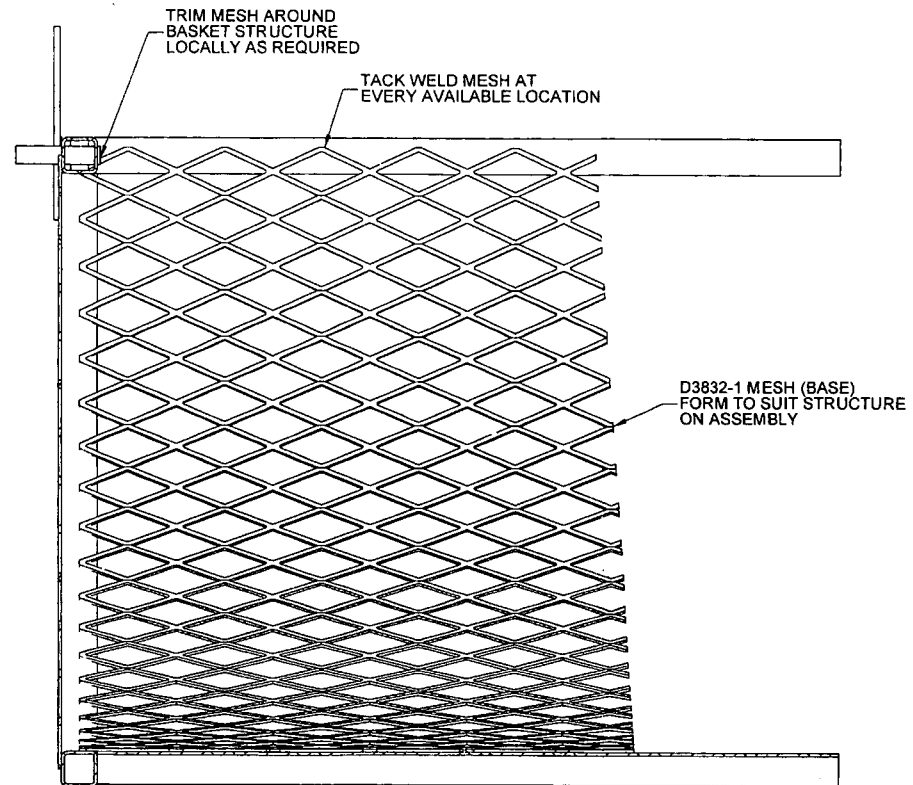
8 7 6 5 4 3 2 1



DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2



SECTION F-F
SCALE 4X D7-2

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. H
CHECKED	14/8	D2221	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
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DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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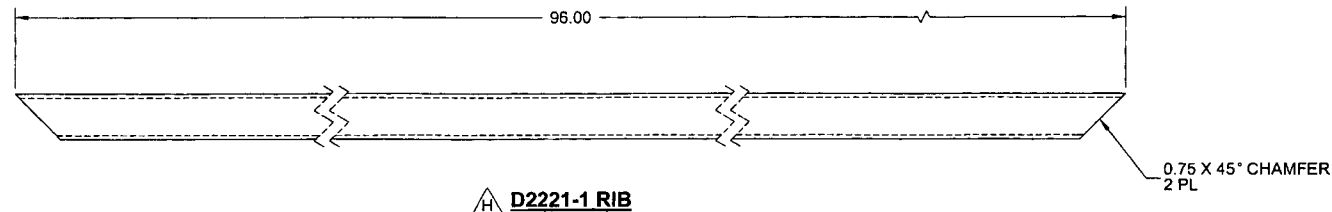
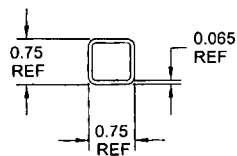
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8 7 6 5 4 3 2 1

D

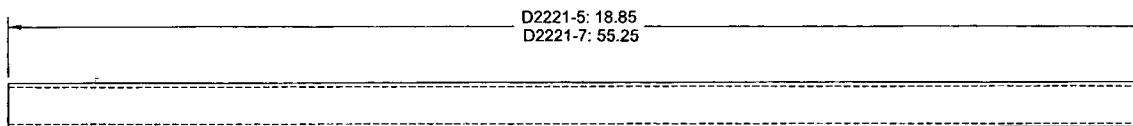
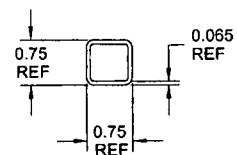
D



D2221-1 RIB

C

C



D2221-5/-7 RIB

B

B

A

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

WLO 57644 **RELEASED**
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. H
MFG. APPR.	MO	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	W	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries